Work Order ID 48243

Friday, June 26, 2009 8:58:01 AM

Item ID: D3363-1
Revision ID: C
Item Name: Console
Start Date: 7/15/2009 **Start Qty:** 4.00
Required Date: 8/3/2009 **Req'd Qty:** 4.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D3363	Rev C

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3363 ***CUT AT 45 DEG GRAIN DIRECTION******* ☐ Dwg Rev: C ☐Prog Rev: C ☐2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00						4	
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									

HB 9-7-2

HB 9-7-2

– Sobotka FAI

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Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00				4	0		
Brake NC	**Memo**	0.00							
Brake NC	Deburr □Form as per Dwg D3363								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
150	Large Fab	0.00							
Large Fab	**Memo**	0.00							
Large Fab	Weld using DT8790 as per Dwg D3363 and QSI 004								

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Start Date: 7/15/2009 **Start Qty:** 4.00
Required Date: 8/3/2009 **Req'd Qty:** 4.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC9- Inspect visual per QSI004- Fusion Welds	0.00	AD 0907.24						
QC	**Memo**	0.00							
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00	=> 8/28/24			(4)	0		
QC	**Memo**	0.00							
Quality Control	1- inspect part with DT8790 jig		AD. FOR CHEM CONV. COAT + QC 3			See old w/o		PTO →	
180	Identify as per dwg & Stock Location: 1852	0.00							
Packaging	**Memo**	0.00				9/7/24		(4)	
Packaging									

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Reference:

Accept

Setup Start

Stop

Cust Item ID:
Customer:

Run Start

Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00				09607	28	KJ	
QC Quality Control	Memo	0.00							

6 9.07.24

Picklist Print

Friday, June 26, 2009 8:58:00 AM

Work Order ID: 48243

Parent Item: D3363-1RevC

Parent Item Name: Console

Comments:

Start Date: 7/15/2009 **Required Date:** 8/3/2009

Start Qty: 4.00 **Required Qty:** 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	0.0000	9.6842			

6061-T6 .063 Sheet

m 110551 HB 9-7-2

Date: Thursday, 28/05/2009 9:11:57 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: CONSOLE
Job Number	: 48243		
Estimate Number	: 10910		
P.O. Number	:	**Part Number**	: D33631
This Issue	: 28/05/2009 **S.O. No.** :	**Drawing Number**	: D3363 REV C
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : SMALL /MED FAB	**Drawing Revision**	: C
Previous Run	: 46179	**Material**	:
Written By	:	**Due Date**	: 04/06/2009 **Qty:** 4 **Um:** Each
Checked & Approved By	: JW 09.05.28		

Comment : Est: B 05.09.09 Remove c'sink rivet holes and add welding step K J/JLM
Est: C 06.11.15 waterjet EC
Est Rev:D 08-07-14 add comment in QC5 inspection DD verified by:ec

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S063	6061-T6 .063 Sheet

Comment: Qty.: 2.4150 sf(s)/Unit Total : 9.6600 sf(s)
6061-T6 .063 thick aluminum Sheet
Batch: 110551 HB 9-7-2

2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D3363 ***CUT AT 45 DEG GRAIN DIRECTION*******
Dwg Rev: C
Prog Rev: C HB 9-7-2

2-Deburr if necessary HB 9-7-2

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

HB 9-7-2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK

Comment: SECOND CHECK 8 09/07/02 KE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** CONSOLE

Job Number: 48243 **Part Number:** D33631

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	BRAKE NC	NC BRAKE

Comment: NC BRAKE
Deburr
Form as per Dwg D3363

09/07/21 (4)

6.0 ✓	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

7.0 ✓	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1
Weld using DT8790 as per Dwg D3363 and QSI 004

8.0 ✓	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION

9.0 ✓	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP
1- inspect part with DT8790 jig

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

BR 09-07-27 (4).

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SA 09/07/27 (X4)

12.0 ✓	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** CONSOLE

Job Number: 48243 **Part Number:** D33631

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	48243
Description: Console	Part Number:	D3363-1
Inspection Dwg: D3363 **Rev:** C		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.100	✓			
Ø0.128	+0.005/-0.001	.131	✓			
Ø0.469	+0.006/-0.001	.471	✓			
14.41	+/-0.030	14.41	✓			
14.097	+/-0.010	14.097	✓			
12.409	+/-0.010	12.409	✓			
11.354	+/-0.010	11.356	✓			
10.706	+/-0.010	10.709	✓			
10.081	+/-0.010	10.086	✓			
4.331	+/-0.010	4.336	✓			
3.706	+/-0.010	3.707	✓			
3.058	+/-0.010	3.058	✓			
2.004	+/-0.010	2.003	✓			
2.366	+/-0.010	2.366	✓			
3.100	+/-0.010	3.103	✓			
5.040	+/-0.010	5.038	✓			
5.415	+/-0.010	5.414	✓			
2.25	+/-0.030	2.249	✓			
19.965	+/-0.010	19.965	✓			
20.366	+/-0.010	20.374	✓			
21.318	+/-0.010	21.318	✓			
22.90	+/-0.030	22.90	✓			
0.315	+/-0.010	.319	✓			
3.706	+/-0.010	3.706	✓			
4.025	+/-0.010	4.028	✓			
7.206	+/-0.010	7.207	✓			
1.75	+/-0.030	1.749	✓			
10.387	+/-0.010	10.391	✓			
19.590	+/-0.010	19.590	✓			

DART AEROSPACE LTD	Work Order:	48243
Description: Console	Part Number:	D3363-1
Inspection Dwg: D3363 **Rev:** C		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.990	+/-0.010	18.990	✓			
1.80	+/-0.030	1.801	✓			
6.390	+/-0.010	6.390	✓			
5.790	+/-0.010	5.796	✓			
4.475	+/-0.010	4.475	✓			
4.100	+/-0.010	4.094	✓			
2.725	+/-0.010	2.721	✓			
2.00	+/-0.030	2.002	✓			
6.363	+/-0.010	6.359	✓			
10.737	+/-0.010	10.746	✓			
11.206	+/-0.010	11.211	✓			
3.206	+/-0.010	3.206	✓			
3.675	+/-0.010	3.672	✓			

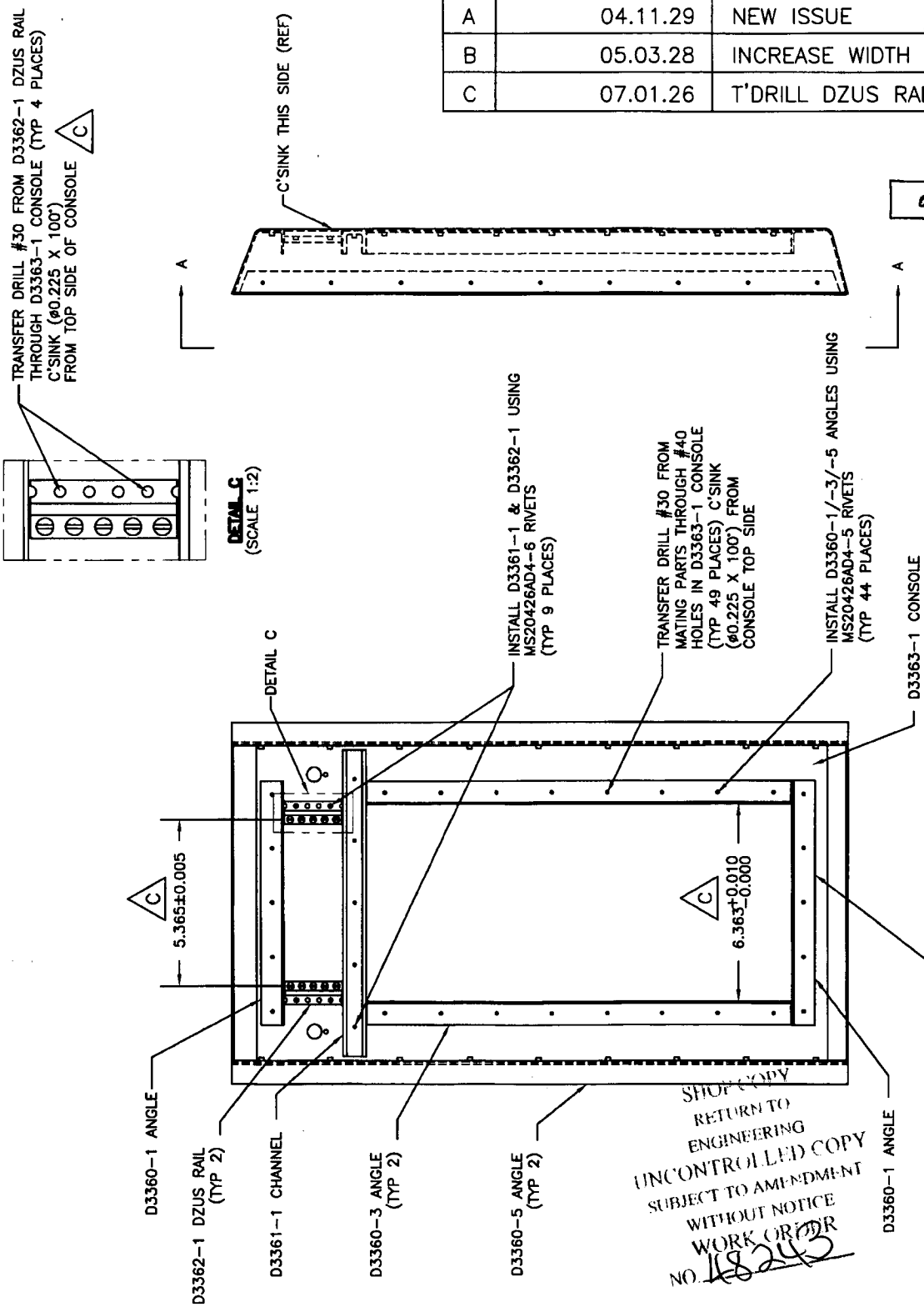
Measured by:	JB	Audited by:	S	Prototype Approval:	N/A
Date:	9-7-2	Date:	09/07/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3363 — REV. C — SHEET 1 OF 3
DATE 07.01.26		TITLE: CONSOLE ASSEMBLY — SCALE 1:5

A	04.11.29	NEW ISSUE
B	05.03.28	INCREASE WIDTH BY 0.125
C	07.01.26	T'DRILL DZUS RAIL, WIDEN BASE CUTOUT

RELEASED
07.06.04



PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY

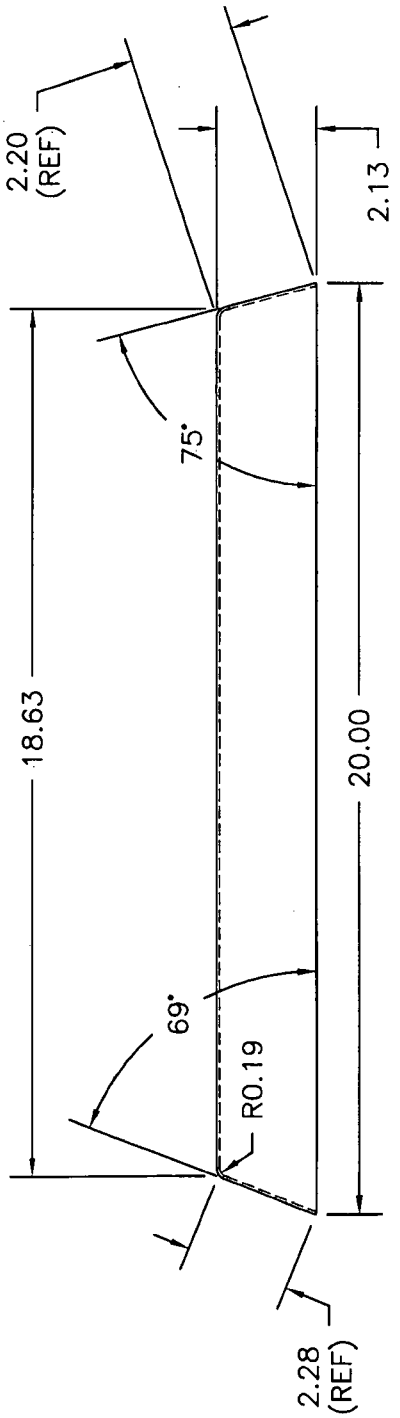
QTY -041	PART NUMBER	DESCRIPTION
X	D3363-041	CONSOLE ASSEMBLY
2	D3360-1	ANGLE
2	D3360-3	ANGLE
2	D3360-5	ANGLE
1	D3361-1	CHANNEL
2	D3362-1	RAIL
1	D3363-1	CONSOLE
44	MS20426AD4-5	RIVET
9	MS20426AD4-6	RIVET

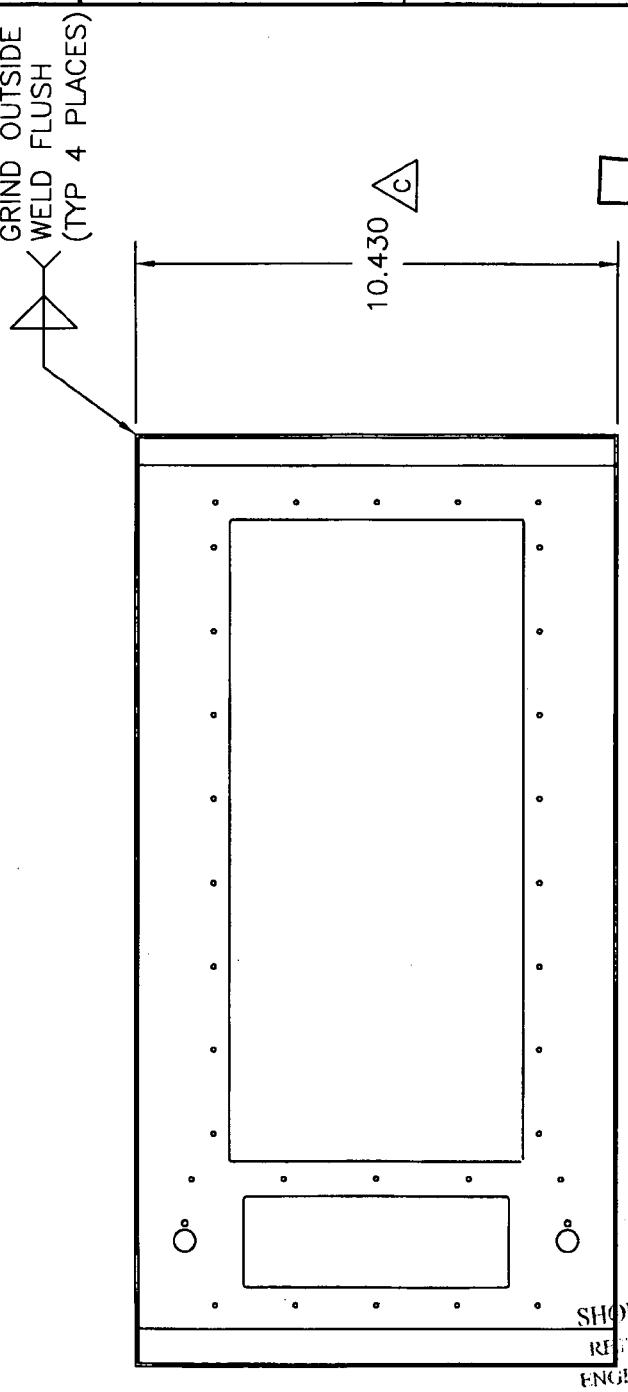
D3363-041 CONSOLE ASSEMBLY
1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

SHOP COPY
RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 182443

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26		TITLE CONSOLE ASSEMBLY	SCALE 1:4

RELEASED
07.06.04





D3363-1 BEND DETAIL
(MAKE FROM D3363-1F FLAT PATTERN)

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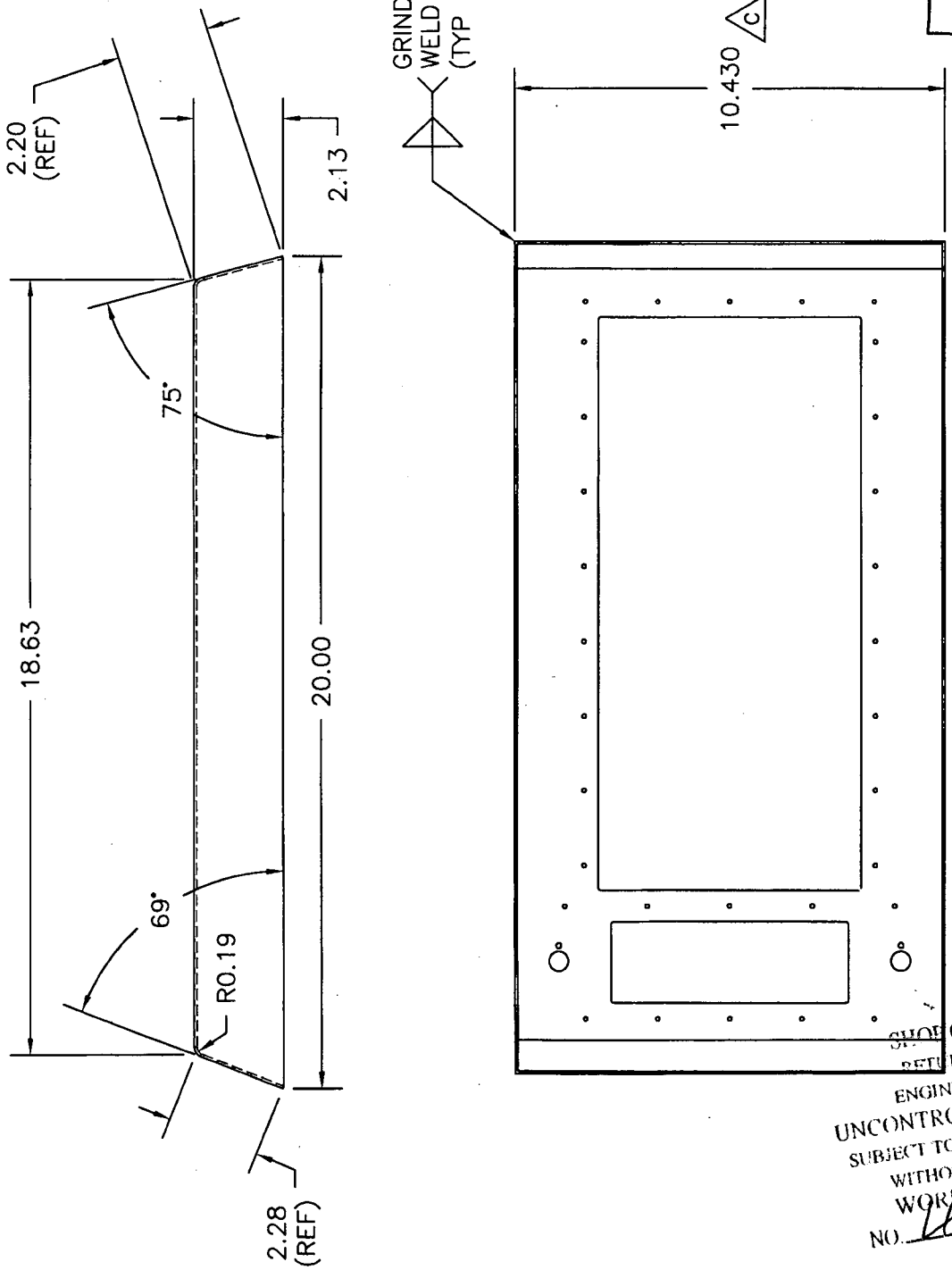
WITHOUT NOTICE
WORK ORDER
NO. 48243

D3363-1 CONSOLE
1) WELD PER DART QSI 004
2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES
4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26		TITLE CONSOLE ASSEMBLY	SCALE 1:4

RELEASED
07.06.04



D3363-1 BEND DETAIL
(MAKE FROM D3363-1F FLAT PATTERN)

D3363-1 CONSOLE
1) WELD PER DART QSI 004
2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES
4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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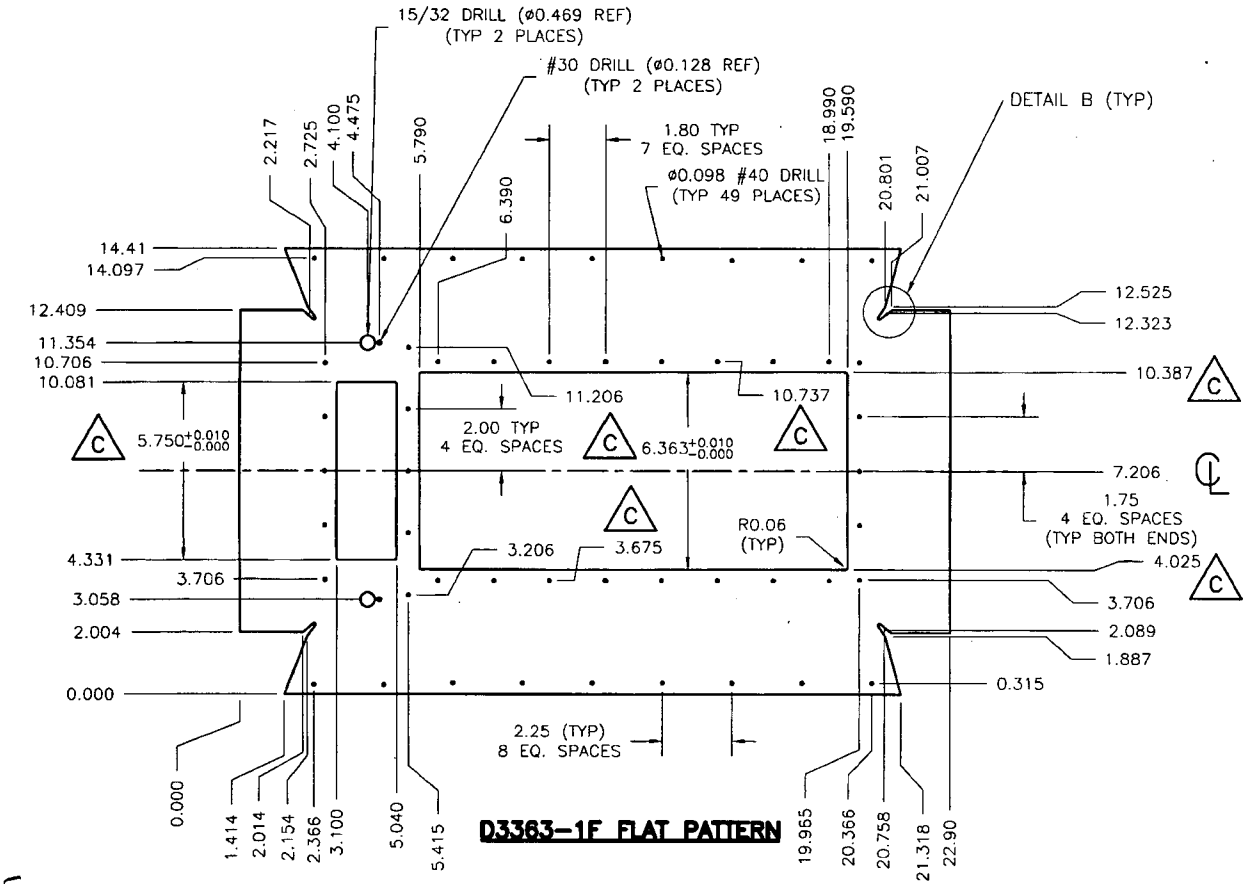
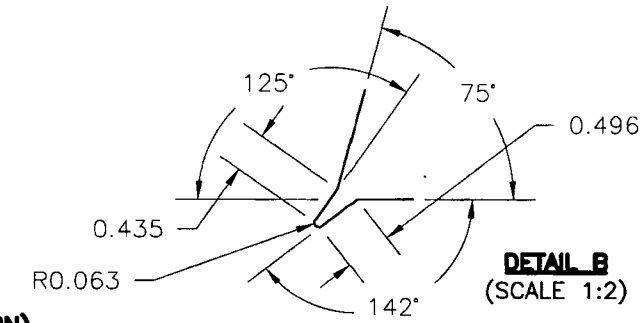
WITHOUT NOTICE
WORK ORDER
NO. 42823



D3363–1F FLAT PATTERN



DETAIL B
(SCALE 1:2)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48203

RELEASED
07.06.04

D3363–1F CONSOLE (FLAT PATTERN)

1) MATERIAL: 6061–T6/T651 ALUMINUM 0.063 THICK
PER QQ–A–250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.063)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) PART IS SYMMETRICAL ABOUT CENTERLINE

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE 07.01.26	DRAWING NO. D3363	REV. C	
	TITLE CONSOLE ASSEMBLY	SHEET 3 OF 3	
		SCALE 1:6	